

Date: Friday, 23/05/2008 9:54:02 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SKIDTUBE ASSEMBLY
<b>Job Number</b>	: 39437		
<b>Estimate Number</b>	: 10022		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D205634011
<b>This Issue</b>	: 23/05/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: N/A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 39436	<b>Drawing Revision</b>	: N/A
		<b>Material</b>	:
		<b>Due Date</b>	: 10/06/2008
<b>Written By</b>	:	<b>Qty:</b>	1 Um: Each
<b>Checked &amp; Approved By</b>	: <u>JLD 08.5.23</u>		
<b>Comment</b>	: Est Rev:P 02.08.28 Removed QC5 from Step 5 KJ		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Photocopy bluefile &amp; type labels per PPP D205-634-011

CHG005

S 0866609 08.5.27 JLD

2.0

39437A

SKID TUBE ASSEMBLY

**Comment:** Sub-Component SKID TUBE ASSEMBLY

D205-634-041 B

39437A

SD

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0

K10003

Saddle, D205-634-011



(x)

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	38649

8/6/09

SD

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

**Comment:** INSPECT 100% KITS FOR COMPLETENESS

S 0866609

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:54:24 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SKID TUBE ASSEMBLY
<b>Job Number</b> :	39437A		
<b>Estimate Number</b> :	10023		
<b>P.O. Number</b> :		<b>Part Number</b> :	D205634041
<b>This Issue</b> :	23/05/2008	<b>Drawing Number</b> :	D2580 REV D
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	D
<b>Previous Run</b> :	39436A	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	10/06/2008
<b>Checked &amp; Approved By</b> :	<u>JLO 08.5.23</u>	<b>Qty:</b>	1
<b>Comment</b> :	Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ		
	Est Rev: O 06.02.28 Added paperwork EC		
	Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634-041 CHG002

N/A

2.0	D25001190	Ext'n -I' Beam Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-190	Skid Tube Extrusion	37544

RT 08.05.26

3.0	D2596	Web, 205 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2596	205 Web	B-39426

AWM

8-5-26

4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

RT 08.05.26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/05/2008 9:54:24 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39437A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ND

8-5-27

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)

2-Open holes to 0.500" as per Dwg D2580without cutting fluid

3-Countersink holes as per Dwg D2580without cutting fluid

4-Deburr and blow out all chips from inside of tube

5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 12107804

Sikaflex expire date: 8-10-01

Start Time: 2:30 Date: 8-5-26

Fin Time: 2:30 Date: 8-5-26

RT 08-05-27

AWM 8-5-27

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

RT 08-05-28

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr ends

2-Prepare tube for welding, remove alodine as required.

AWM 8-5-28

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39437A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/05/28

10.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	33321

BE 08/05/28

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	38659

BE 08/05/28

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m107877

BE 08/05/28

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m107877

BE 08/05/28

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

AWM 8-5-30

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

AWM 8-5-30

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

3-6-2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39437A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/06/02 (D)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/02 (D)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

FL 08/06/03 (D)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

2:15

M 107925.

OVEN TEMPERATURE:

320°

FINISH TIME:

2:45

BL 08-06-03 (D)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-06-05 (D)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

13 38 39 5

HL

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M 100 188

HL

08-06-05 (D)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39437A

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104885

HL

21.0	ALS71032130	Insert
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Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: M105819

HL

22.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M108161

HL

23.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M108077

HL

24.0	D356613	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32744

HL

25.0	D35665	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B39237

HL

26.0	D35661	Gasket
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B39681

HL

08.06.05

X1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 23/05/2008 9:54:25 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39437A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38253

HL

28.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

\* Batch: B39133

HL

29.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B38656

HL

30.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B39235

HL

31.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: B29908

HL

32.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: B37926

HL

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M10780 v

HL

08-06/054

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 23/05/2008 9:54:25 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39437A

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ Sikaflex expire date: 08/10

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

✓ 3-Inspect for foreign object per QSI 024

✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 11109804

Sikaflex expire date: 08/10

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M107892

08-06-06 (X)

34.0

QC5

INSPECT WORK TO CURRENT STEP



08/06/06 (X)



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



(X)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location:

PPP Rev:

PPP 39437

8/6/9

SV

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/10 (X)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08-06-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *314381*

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

**NOTE:** Date & initial all entries

NO. 156

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 39209 A  
Part number: D209 669 043  
Description: Skid tube Cobra  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[ ] fail[ ]

UNACCEPTABLE

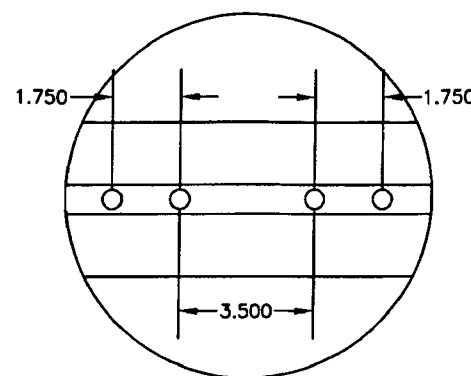
Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Pet. Duval Date of Test Coupon 08-05-22  
Welder Barclay Elliot Date of Test Coupon 08/05/22

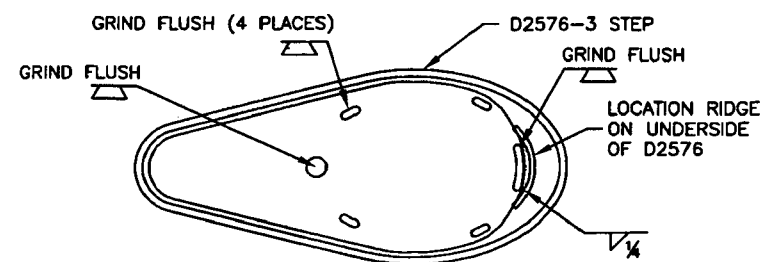
The above named individual is qualified in accordance with AWS D17.1.2001 to weld

**DETAIL A**  
SCALE 5:24

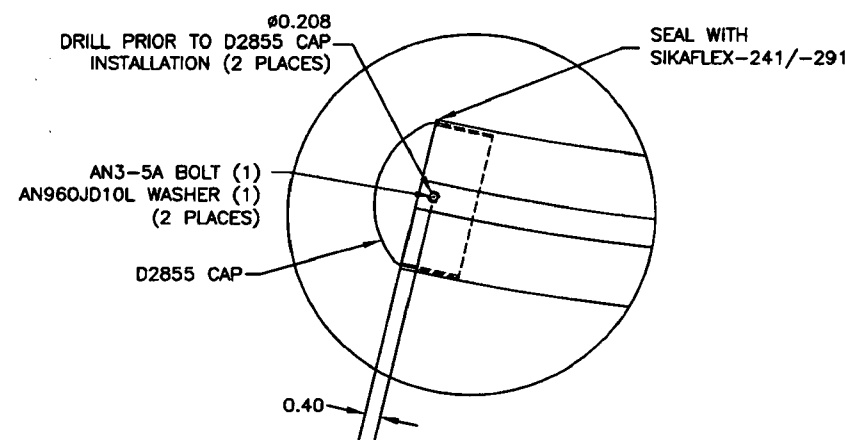


**RELEASED**  
07-06-28

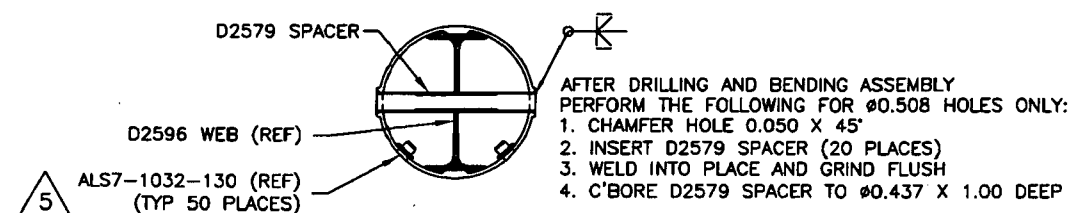
**DETAIL B**  
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**DETAIL C**  
SCALE 5:24



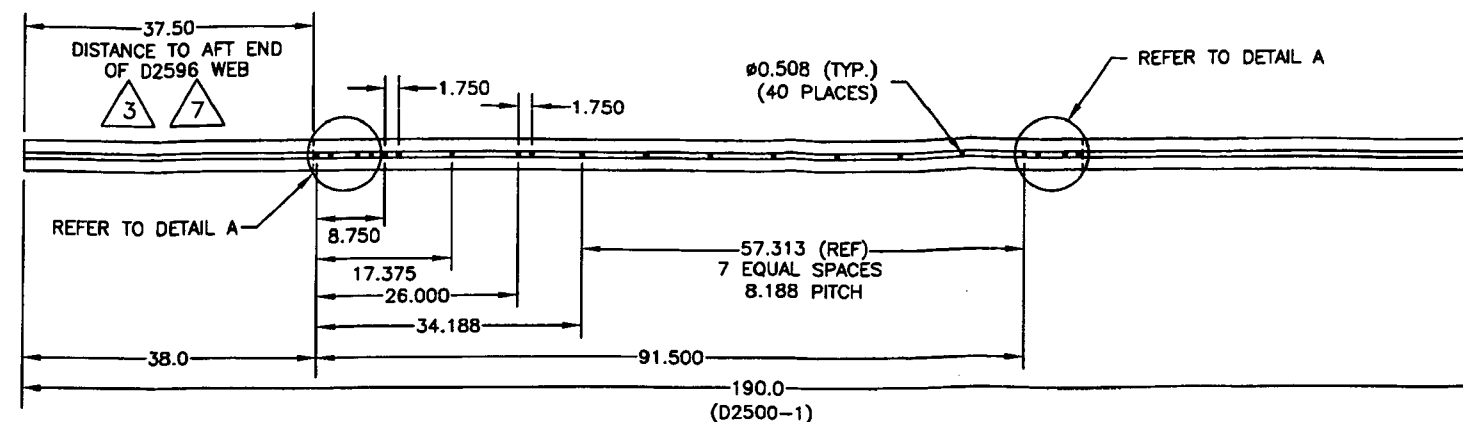
**SECTION D-D**  
SCALE 5:24



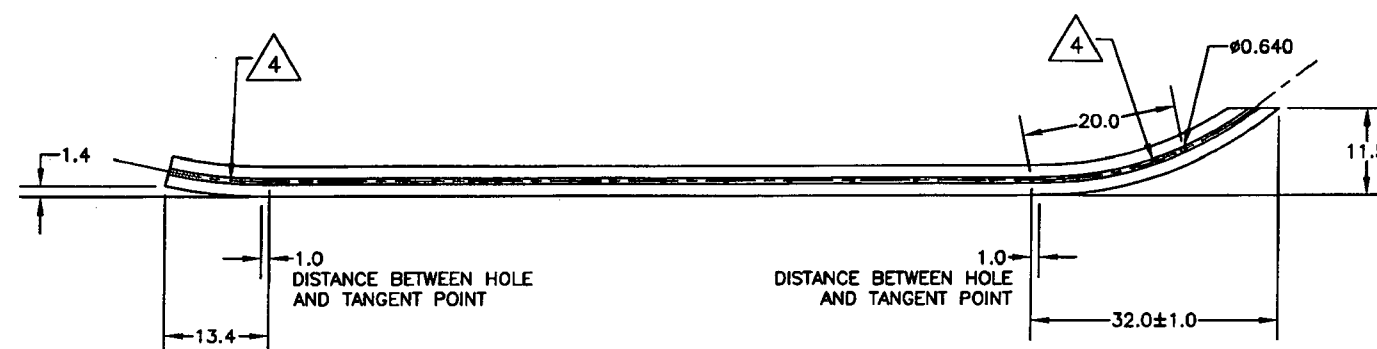
**D2580-041 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

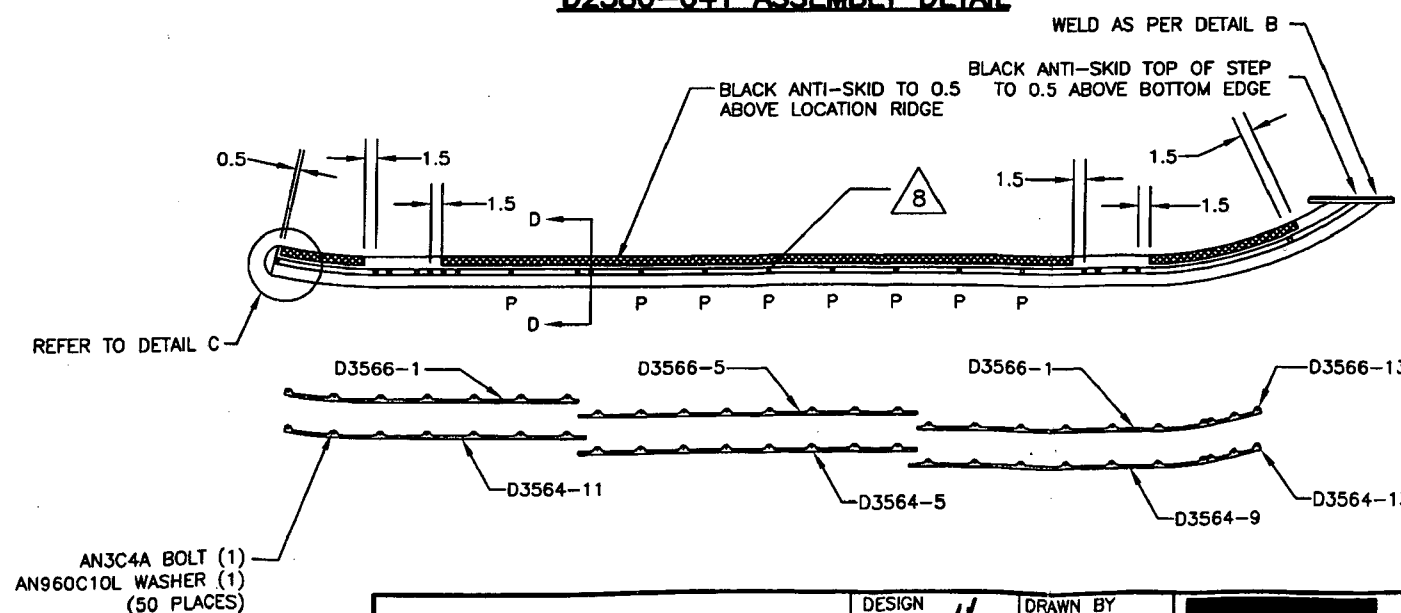
**D2580-1 DRILLING DETAIL**



**D2580-1 BENDING AND CUTTING DETAIL**



**D2580-041 ASSEMBLY DETAIL**



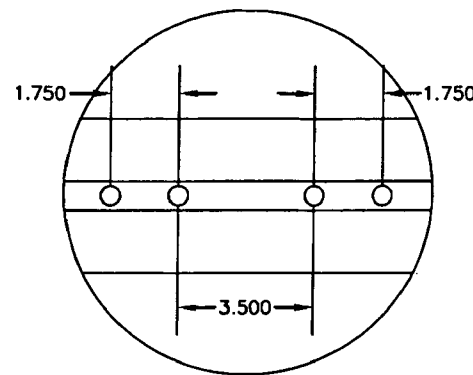
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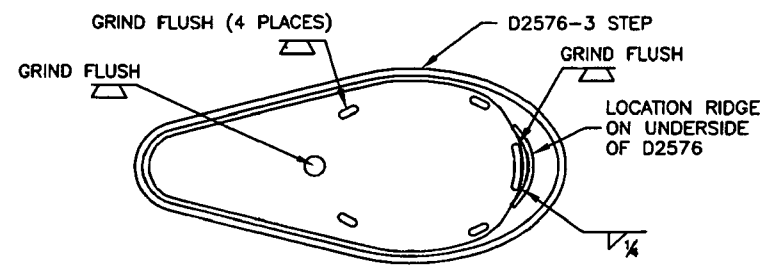
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CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. D
DATE	07.02.27	TITLE	205 SKIDTUBE ASSEMBLY	D2580	SHEET 2 OF 3
		SCALE	1:24		

**DETAIL E**  
SCALE 5:24

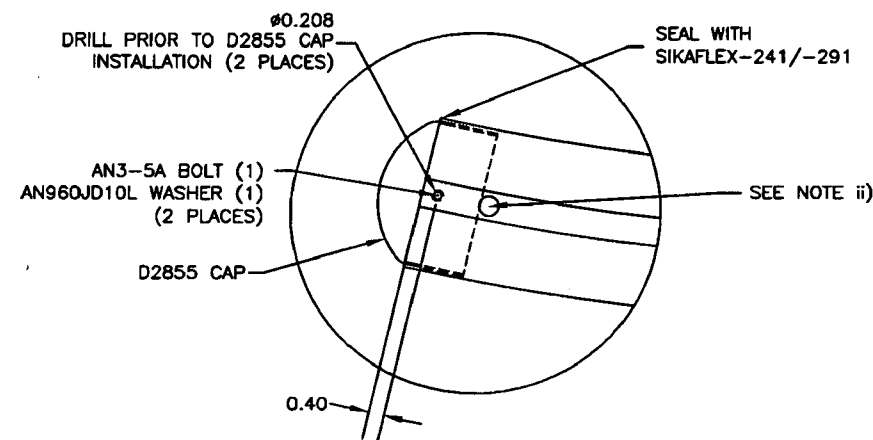


**RELEASED**  
07.02.27

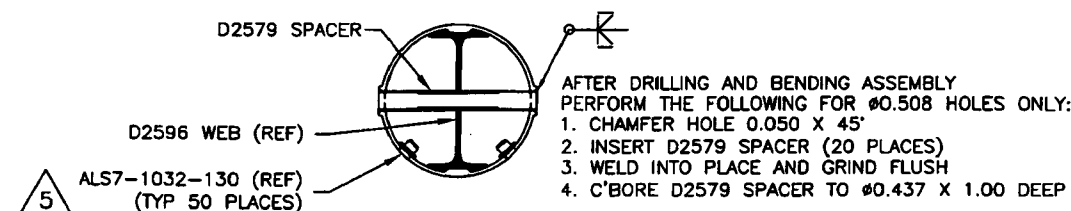
**DETAIL F**  
SCALE 5:24



**DETAIL G**  
SCALE 5:24



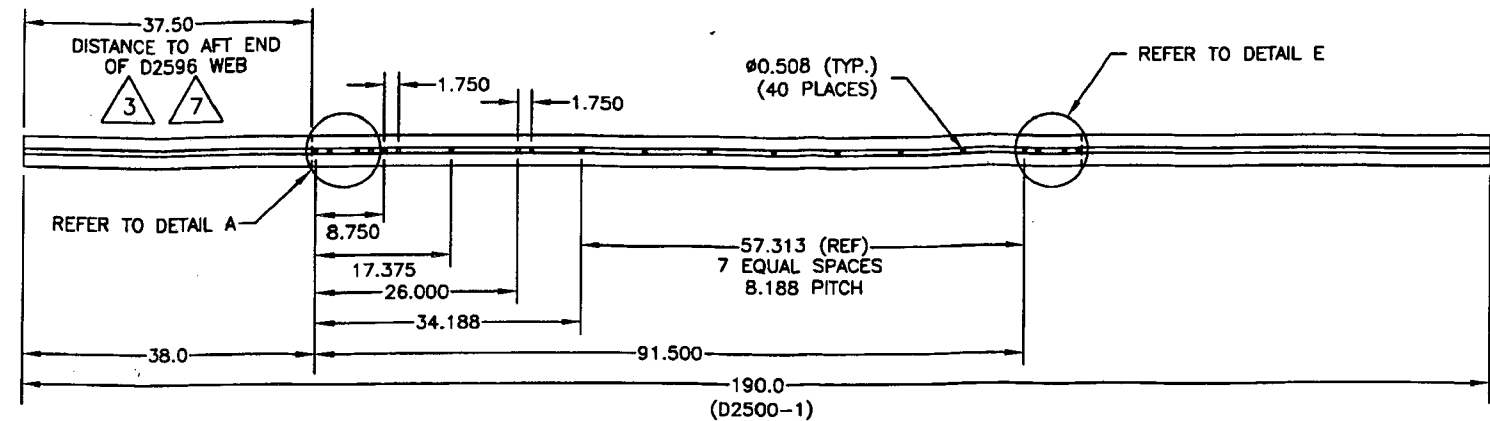
**SECTION H-H**  
SCALE 5:24



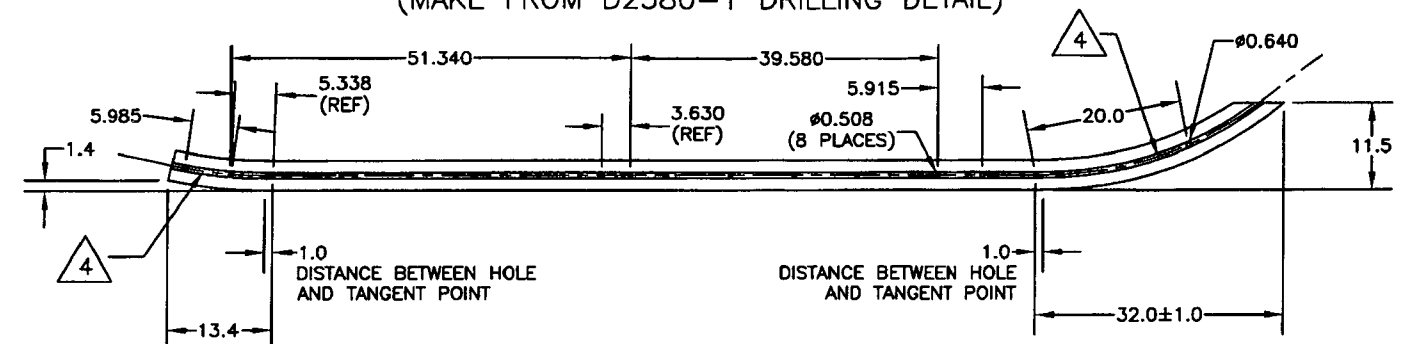
**D2580-045 NOTES**

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

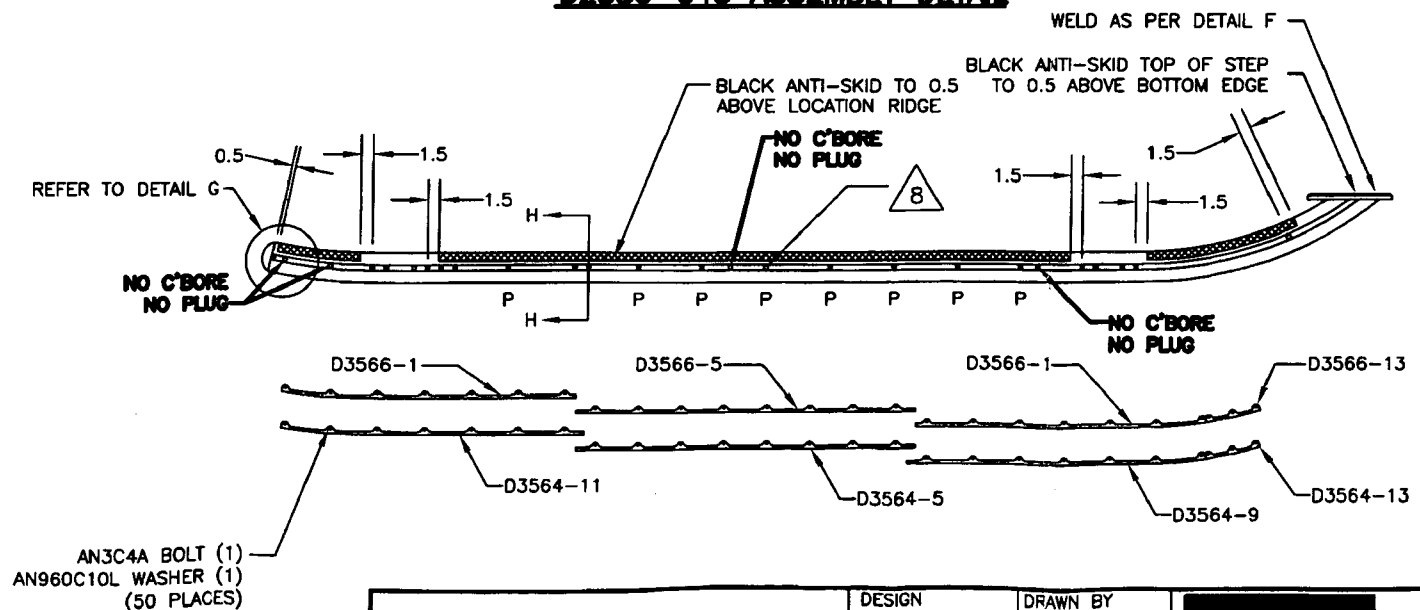
**D2580-1 DRILLING DETAIL**



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



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DESIGN RH	DRAWN BY RH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

